

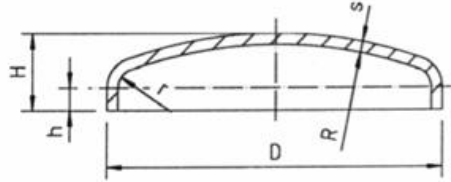


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Standard heads



- D = outside dimension
- s = wall thickness before forming
- r = inside knuckle radius (on request)
- R = inside radius (on request)
- h = Straight flange height
- H = total height

Tolerances

Material	Diameter in mm	Tolerance (on the circumference)
Unalloyed steel and Low alloy steel	D < 100	+3 / -3 mm
	100 ≤ D < 300	+4 / -4 mm
	300 ≤ D < 1000	+0.4 / -0.4 %
	1000 ≤ D < 4000	+0.3 / -0.3 %
Stainless steel	D < 100	+3 / -3 mm
	100 ≤ D < 300	+5 / -5 mm
	300 ≤ D < 4000	+ 0,5 / -0,7 %

Height (H)

+10/-0 mm or +0,015D/-0 mm (*highest value*)

Roundness

$$U = \frac{2(D_{\max} - D_{\min})}{D_{\max} + D_{\min}} \times 100\% \quad (\text{max } 1\%) \quad (D_{\max} - D_{\min} \text{ max. } 30\text{mm})$$